

Work Order ID 86337

86337

Page 1

Item ID: D2432

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206 (24") Bearpaw

Start Date: 27/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/12 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

PO/B. 12/07/10

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

PO/B. 12/07/10

2 0
PTO
2 0

B12-7-5

W/O: 86337		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2432 PAR #: _____ Fault Category: Mechanism NCR: (Yes) No DQA: Aut Date: 12/07/19
 Resolution: _____ Disposition: Se Adapter QA: N/C Closed: cl Date: 12/1/20

NCR: 12-1595		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/07/10	130	DIM F goes Down to 0.228. NC: Origin set too low. operator error	12/07/10 QS104Z	ACCEPTABLE THIS PART ONLY (QTY 1). AREA OF BYPASS IS NOT CRITICAL	RT 12-07-12	12/07/16	12/07/10 QS104Z	DAS 16 9-8 12/9/16

NOTE: Date & initial all entries

Work Order ID 86337

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Item ID: D2432

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206 (24") Bearpaw

Start Date: 27/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

inf 12/07/16

2

10

151 Identify as per dwg & Stock Location: *495*

0.00

151

Packaging

Memo

0.00

Packaging

12/7/17

190 QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/7/18

WMC 12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-27-12 3:17:50 PM

Page 1

Work Order ID: 86337

86337

Parent Item: D2432

D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	72.0100	3.7	7.4			

MUHMWB10

UHMW 1" Black

**

B2-7-5

Location	Loc Qty	Loc Code
MAT018	48.9	
120972	1	
121346	27.1	
121954	20.8	
MAT019	1.5	
118814	1.5	
ST052	21.60999474	
121277	12.8	
121278	8.80999474	

122286

(2)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86337
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063	✓		VERN	PHD-01
B	5.500	+/-0.030	5.502	✓		"	"
C	0.200	+/-0.030	0.197	✓		Mic	PHD-09
D	0.25 x 45°	+/-0.030	0.250	✓		VERN	PHD-01
E	R0.250	+/-0.030	0.250	✓		Rad gauge	
F	0.250	+/-0.010	0.250	✓		Mic	118-120
G	0.625	+/-0.030	0.627	✓		VERN	PHD-01
H	0.375	+/-0.010	0.380	✓		Mic	118-120
I	0.950	+0.030/0.010	0.960	✓		VERN	PHD-01
J	19.000	+/-0.030	19.000	✓		M. TABE	PHD-11
K	3.14	+/-0.030	3.138	✓		VERN	PHD-01
L	3.28	+/-0.030	3.310	✓		"	"
M	Ø0.260	+0.005/-0.000	0.260	✓		"	"
N	Ø0.93	+/-0.030	0.930	✓		"	"
O	0.30	+0.030/-0.000	0.300	✓		Mic	PHD-09
P	23.750	+/-0.030	23.750	✓		M. TABE	PHD-11
Q	7.375	+/-0.030	7.375	✓		H. gauge	
R	4.250	+/-0.010	4.250	✓		VERN	PHD-01
S	2.000	+/-0.030	2.000	✓		"	"
T	9.000	+/-0.010	9.000	✓		H. gauge	
U	9.000	+/-0.010	9.000	✓		"	
V	0.375	+/-0.010	0.377	✓		VERN	PHD-01

Measured by: <u>PO/BA</u>	Audited by: <u>con</u>	Prototype Approval:	N/A
Date: <u>12/07/10</u>	Date: <u>12/07/10</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF <u>AF</u>

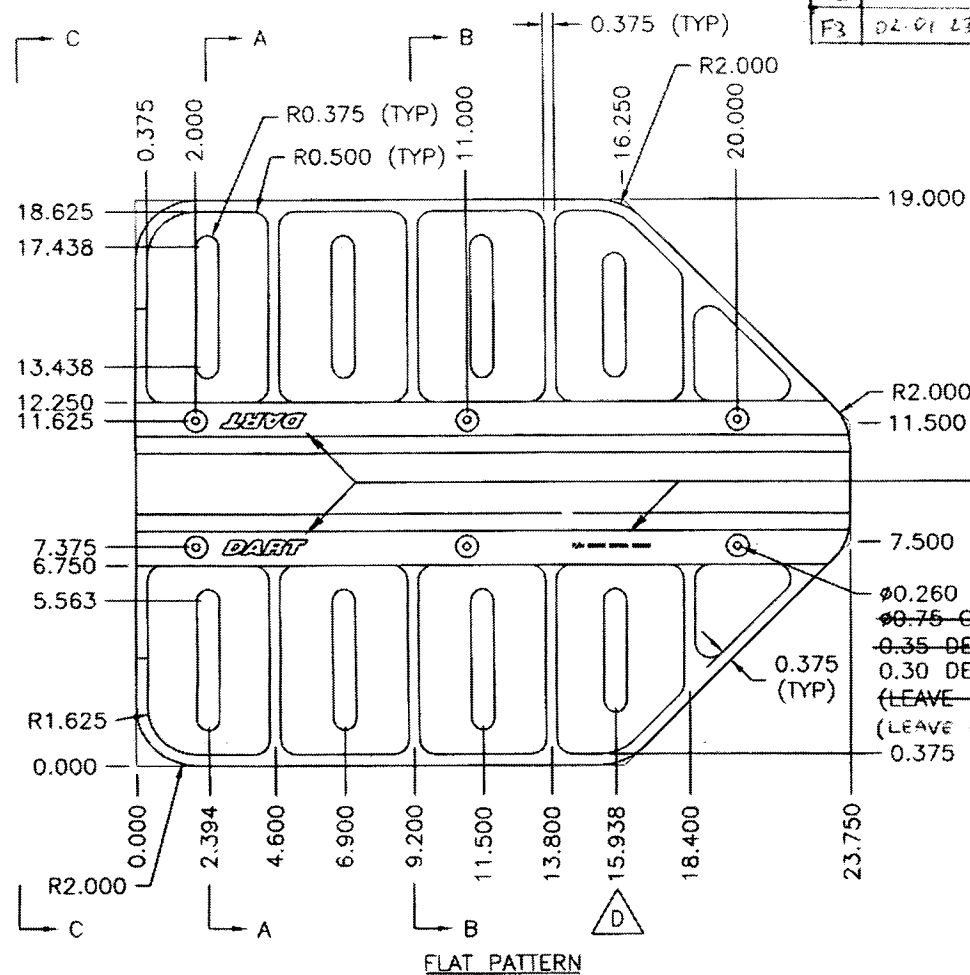
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NOTE: Date & initial all entries



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

F1	99.03.03	ADD DEC 9143
F2	01.03.28	Q0.75 WAS Q0.75 Q1.15
F3	02.01.23	CLARIFY CORE DIMS Q1.15 RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

EFFECTIVE	DECS
9143	

RELEASED
93.06.17 KE

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
86337
MLJ



12/06/28

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MLJ	MLJ	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE
		1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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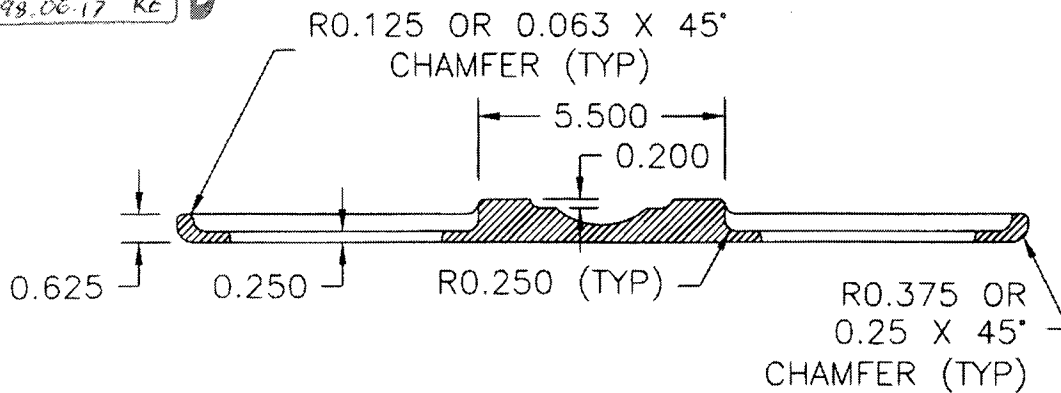
NOTE: Date & initial all entries

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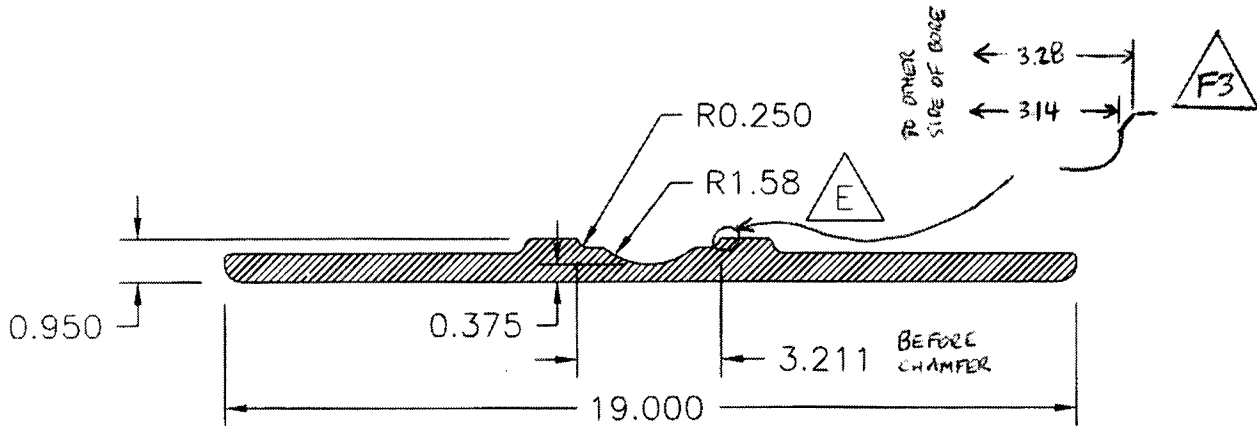


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

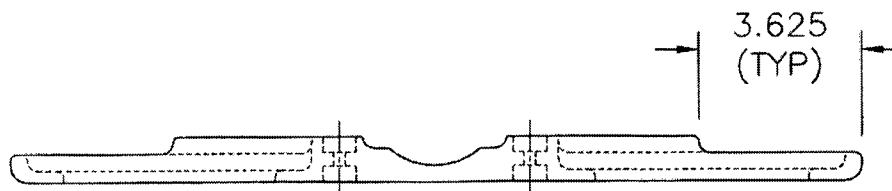
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98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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